

providing a belt-shaped thick steel material having one of an L-shaped cross-section and a U-shaped cross-section and having two elongated sides and two ends; and

forming the material into a cylinder so that the ends of the belt-shaped thick steel material abut each other by using a center roller to be driven to rotate which is positioned and fixed in a predetermined position and a pair of bending rollers to be driven to rotate which is disposed opposing the center roller at one side of the center roller, movable toward and away from the center roller, the belt-shaped thick steel material having one of an L-shaped cross-section and a U-shaped cross-section being bent by being transferred between the center roller and the pair of bending rollers.

4. (Amended) A bending device for bending a belt-shaped thick steel material having two elongated sides and two ends to form a cylinder where the ends of the belt-shaped thick steel material abut each other, the bending device comprising:

a center roller to be driven to rotate positioned and fixed in a predetermined position;

and

a pair of bending rollers to be driven to rotate disposed opposing the center roller at one side of the center roller, movable toward and away from the center roller, the belt-shaped thick steel material being bent by being transferred between the center roller and the pair of bending rollers,

wherein the center roller is provided with an annular recess formed therein around the center roller, the pair of bending rollers are respectfully provided with annular convex portions

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formed thereon around the bending rollers, the convex portions to be inserted in the annular recess of the center roller at a predetermined position of the annular recess of the center roller, and the belt-shaped thick steel material having one of an L-shaped cross-section and a U-shaped cross-section is transferred between the center roller and the pair of bending rollers in a manner such that a concave portion of the belt-shaped thick steel member having one of an L-shaped cross-section and a U-shaped cross-section faces toward the outside at the annular recess of the center roller and the convex portions of the pair of bending rollers are positioned in the concave portion of the belt-shaped thick steel material having one of an L-shaped cross-section and a U-shaped cross-section.